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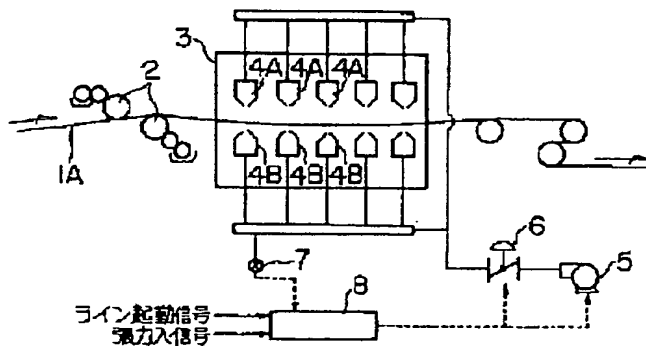
APPLICATION DATE : 28-09-93
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APPLICANT : NKK CORP;

INVENTOR : KASAI KATSUJI;

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TITLE : METHOD FOR CONTROLLING
FLOATING FORCE OF STEEL STRIP IN
HEAT TREATING FURNACE



ABSTRACT : PURPOSE: To prevent the occurrence of cracking in the edge parts of a steel strip by gradually lowering the floating force applied on this steel strip and slowly placing the steel strip on lower nozzles.

CONSTITUTION: The steel strip 1A which moves horizontally above the lower nozzles 4A disposed in a heat treating furnace 3 and is coated with films on the surfaces is slowly places on the lower nozzles 4A by gradually dropping the pressure of the lower nozzle 4A in the case of stopping of the movement of the steel strip 1A in the method for controlling the floating force imparted on the steel strip 1A at the time of injecting hot air toward the rear surface of the steel strip 1A from the lower nozzles 4A and baking the films described above to the surfaces of the steel strip in the state of floating the steel strip 1A from the lower nozzles 4A. On the other hand, the steel strip 1A is slowly floated from the lower nozzles 4A by gradually increasing the lower nozzle pressure in the case of starting of passage of the sheet.

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